

21. **Allowable Emissions:** The Permittee shall not allow emissions into the atmosphere to exceed any of the following limits:

	Daily Emission Limits	Twelve Month Rolling Average Emission Limits
Particulates Smaller than Ten Micron (PM ₁₀)		
Total Particulates		

The twelve month rolling average shall be calculated at the end of each calendar month by summing the total emissions over the most recent twelve calendar months.

The Permittee shall not discharge into the atmosphere from the powder coating operations any particulate matter in excess of 20 per cent opacity.

22. **Controls:**

- a. The Permittee shall conduct all powder coating activities in a booth equipped with exhaust filters which are certified by the manufacturer and accepted by the Control Officer as having a minimum particulate removal efficiency of at least 92%. The Permittee shall install and maintain the exhaust filters in accordance with the manufacturer's recommendations, with no gaps or visible openings.
- b. All powder coating operations shall be conducted utilizing a spray gun with a transfer efficiency of at least 65% as certified by the manufacturer and accepted by the Control Officer. Other methods of application may be used if they result in at least a 65% transfer efficiency.
- c. The exhaust fan from the booth shall be operating whenever any powder coating operations are being conducted in the booth.
- d. The booth doors shall be completely closed whenever any powder coating operation is in progress.
- e. The booth shall be completely self contained regarding the escape of particulates. There shall be no openings in the outer perimeter walls of the booth that are not exhausted through the filter or cyclone. All connections to the filter or cyclone shall be leak free and free from defects. The filter or cyclone will be free from leaks that discharge particulates into the atmosphere except that discharge designed to exit through the filter.
- f. All loose particulate matter will be shaken off the parts being coated or otherwise removed while the part is in the booth and before the part is removed from the booth to be taken to the oven.

23. **Material Limitations:** The Permittee shall not apply any surface coating, including any VOC-containing materials added to the original coating supplied by the manufacturer, which contains VOC in excess of the limits in Table I of Rule 336 §301.

24. **Record Keeping:**

- a. The Permittee shall maintain a current list of VOC containing materials used for surface coating operations at the facility, stating the VOC content of each in either pounds per gallon or grams per liter.
 - b. The Permittee shall keep a log demonstrating that all training requirements of these Permit Conditions are being met.
 - c. The Permittee shall keep a log of the amount of powder coating used in the facility daily.
25. **Training:** The Permittee shall fully train all individuals before they are allowed to operate any powder coating equipment. Training shall include, at a minimum, proper application techniques, cleaning procedures, and equipment setup and adjustment as well as record keeping requirements. Refresher training shall be given at least annually.
26. **Other:**
- a. **Spray Equipment Cleanup:**
The Permittee shall not use materials containing VOCs in the cleanup of the spray equipment used in powder coating operations unless
 - 1) the equipment is disassembled and cleaned in a solvent vat which is closed when not in use or,
 - 2) the used cleaning compounds are collected in a container which is closed when not in use and the solvent is disposed of in a manner which does not allow it to evaporate into the atmosphere or,
 - 3) cleaning is done by other methods which have been approved in writing by the Control Officer.
 - b. **VOC Containment and Disposal:**
The Permittee shall take all reasonable measures to keep VOCs from evaporating into the atmosphere including, but not limited to:
 - 1) All materials from which VOCs can evaporate, including coatings, fresh solvent, used solvent, waste solvent and solvent soaked rags and residues shall be stored in closed containers when not in use. Such containers one gallon and larger shall be legibly labeled with their contents. VOC containing materials shall be disposed of in closed containers.
 - 2) All containers and mixing tanks containing VOCs shall be leak free and shall be kept covered except when the materials are being transferred or when the containers are being cleaned.